

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application:

LISTING OF CLAIMS:

Claim 1. (Canceled)

2. (Currently Amended) In a method ~~Method~~ according to Claim ~~[[1]]~~ 24, wherein [the] each correction value is determined according to a difference between the angular geometries of the front and rear edges.

3. (Currently Amended) In a method ~~Method~~ according to Claim ~~[[1]]~~ 24, wherein the correction value is determined according to a difference between the angular geometries measured for each of the front and rear edges and a predetermined reference angular value.

Claim 4. (Canceled).

5. (Currently Amended) In a method ~~Method~~ according to Claim ~~[[4]]~~ 24, ~~using a front transporter and a rear transporter, and~~ further comprising the following steps:

unwinding onto a conveyer a continuous strip of belt from a feed system,

cutting the belt strip along a line parallel to ply cords of the belt, so as to leave the front edge clear, gripping the front area by means of the gripping assemblies situated on the front transporter,

unwinding a predetermined length $[(L1)]$ of belt strip,

determining the angular geometry of the front edge upon passing across the fixed detection line,

gripping the rear area by means of the gripping assemblies situated on the rear transporter,

cutting the strip of belt along a line parallel to the ply cords so as to leave clear the rear edge and obtain a belt ply,

advancing the belt ply by advancing the conveyor and the front and rear transporters simultaneously.

determining the angular geometry of the rear edge upon passing across the detection line,

aligning the front edge and the rear edge,

bringing the laying form closer,

depositing the front area on the laying form,

winding the intermediate area around the laying form, and

depositing the rear area on the laying form.

Claim 6. (Canceled).

7. (Currently Amended) In a method ~~Method~~ according to claim 5, wherein the advancements of the conveyer and transporters are respectively synchronized with the rotation of the laying form.

Claim 8. (Canceled).

9. (Currently Amended) In a method ~~Method~~ according to Claim ~~[[4]]~~ 5, in which the length of the ply is adjusted by moving the two transporters longitudinally and in respective opposite directions by the required correction values.

10. (Currently Amended) In a method ~~Method~~ according to claim 5, wherein the length of the ply is adjusted by modifying, in a given ratio, the ~~synchronisation~~ synchronization of the advance of the conveyer and transporters with respect to the rotation of the laying form.

Claim 11. (Canceled)

12. (Currently Amended) In a method ~~Method~~ according to claim [5] 24, wherein the laying form has a curved crown having a large diameter and a small diameter, further comprising the following steps:

unwinding and cutting the belt strip in order to obtain a ply of predetermined length ($L1$) close to a smallest circumference ($\pi \times D1$), putting the ply under tension by stretching to a length ($L2$) such that the ratio $k = L2/L1$ is between 1 and $D2/D1$, and

effecting the alignment of the ply edges by adding to the correction values determined by the analysis of the angular geometries measured for each of the front and rear edges a predetermined value for compensating for the angular variations introduced by the curve and the tensioning of the ply.

Claims 13-23 (Canceled).

24. (New) In a method of laying a tire belt ply on a generally cylindrical form, the ply comprising a front area, a rear area, and an intermediate area, the front and rear areas being bordered by respective front and rear edges, the improvement comprising the steps of:

A. providing movable front and rear transporters, each transporter carrying a toe gripping assembly, a central sector gripping assembly and a heel

gripping assembly of which only the toe gripping assemblies are provided with respective front and rear ply edge correctors;

B. causing the gripping assemblies of the front transporter to grip respectively a toe, a central gripping sector, and a heel of the ply's front area, and causing the gripping assemblies of the rear transporter to grip respectively a toe, a central gripping sector, and a heel of the ply's rear area;

C. moving the front and rear transporters so that the front and rear edges of the ply pass across a fixed detector line for measuring angular geometries of the front and rear edges and determining therefrom a correction value for the front and rear edges; and

D. aligning the front and rear edges by activating the front ply edge corrector and the rear ply edge corrector to move the toes of the ply's front and rear edges, respectively, in accordance with the correction value, while keeping fixed the central sector and the heel of each of the front and rear edges.